

Date: Monday, 12/5/2005 9:24:54 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BAR
Job Number :	25100		
Estimate Number :	10386		
P.O. Number :	N/A	Part Number :	D31961
This Issue :	12/5/2005	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3196 REV A
First Issue :	12/5/2005	Project Number :	N/A
Previous Run :	N/A	Drawing Revision :	A
	Type :	Material :	N/A
		Due Date :	12/20/2005
Written By :	See comment below		Qty: 10 Um: Each
Checked & Approved By :	See comment below		
Comment :	Est Rev: A New Issue 05-11-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
<p>Comment: Qty.: 2.2922 f(s)/Unit Total: 22.9215 f(s) Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) (M6061T6B0.750x01.500) Identify for D3196-1 M18571 236.25" Batch: M15031 26" J.G 05/12/06 10</p>		
2.0	BAND SAW	BAND SAW
<p>Comment: BAND SAW Cut blank: (0.75" x 1.50") x 26.200" long Bar J.G 05/12/06 10</p>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<p>Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3196-1 as per Folio FA339 and Dwg D3196Identify as D3196-1 2-Deburr SA 05.12.08 10</p>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE SA 05.12.08 10</p>		
5.0	QC8	SECOND CHECK
<p>Comment: SECOND CHECK SA 05/12/10 10</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 6/2/10 Date: 05/12/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/5/2005 9:25:00 AM
User: Linda Lacelle


Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 25100

Part Number: D31961

Job Number: 

Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 12/11/05 10

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

05/12/13 10

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 92

05/12/15 10

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21 SAC 05/12/20

05/12/16 10

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Bar		Part Number:	D3196-1
Inspection Dwg: D3196 Rev: A		Page 1 of 1	

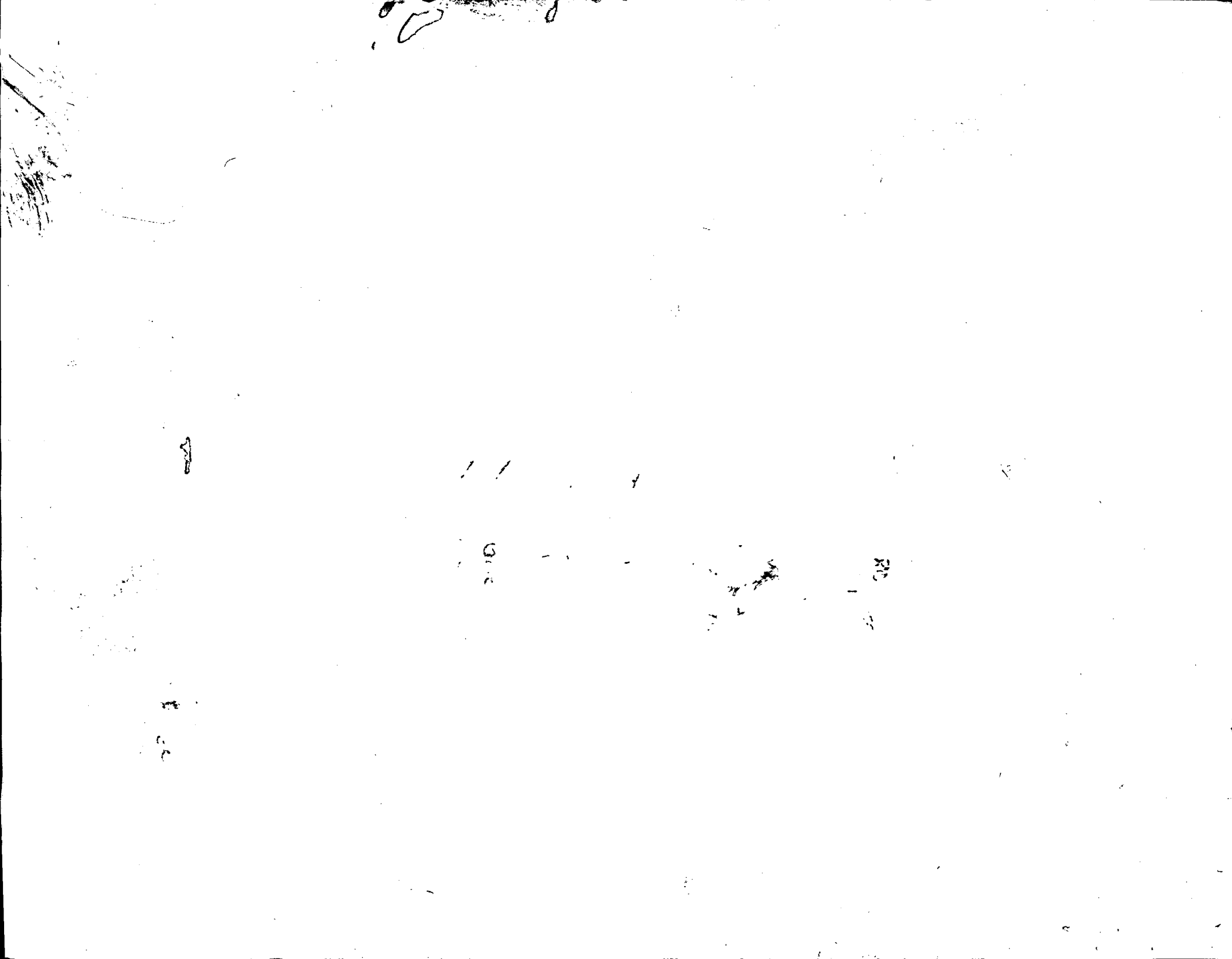
FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.094	+/-0.010	26.100	/		Tape	
4.083	+/-0.010	4.088	/			
17.928	+/-0.005	17.928	/			
0.750	+/-0.005	.752	/			
1.500	+/-0.010	1.500	/			Mat. width
Ø0.344	+0.005/-0.000	Ø.345	/			
Ø0.660 x 100°	+/-0.005	.665 x 100°	/			
0.060 x 45°	+/-0.010	.060 x 45°	/			
0.750	+/-0.010	.750	/			Mat. thickness
0.250	+/-0.010	.251	/			
3.583	+/-0.010	3.580	/			
9.000	+/-0.010	9.000	/			
16.844	+/-0.010	16.850	/		Tape	
21.511	+/-0.010	21.510	/		Tape	
R0.125	+/-0.010	N/A	/			
1.000	+/-0.010	1.000	/			
R0.125	+/-0.010	R.125	/			

Measured by:	SD	Audited by:	BA	Prototype Approval:	N/A
Date:	05.12.08	Date:	05.12.08	Date:	N/A

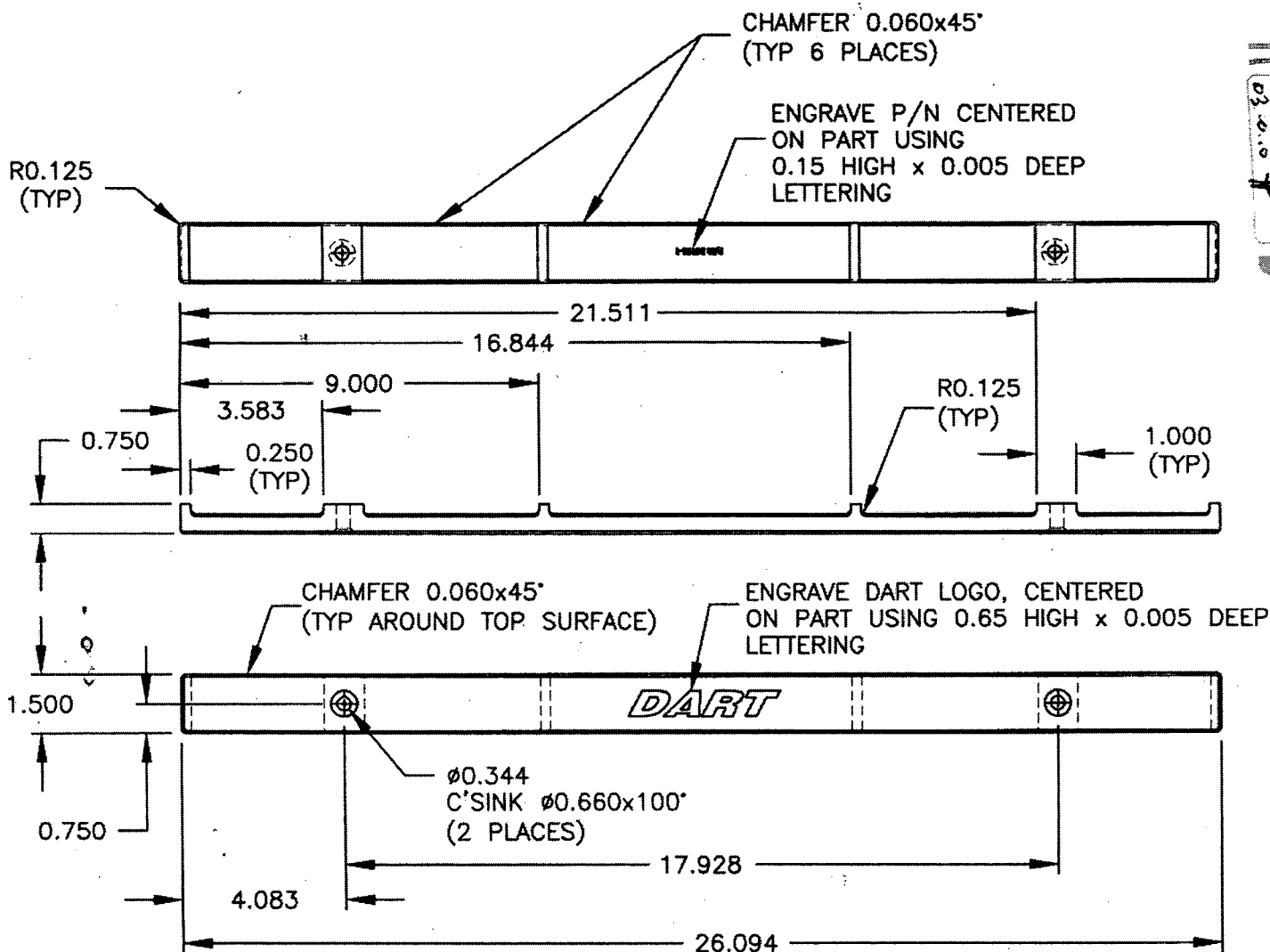
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702:01/-013)	KJ/RF	



QA COPY ISSUED

03.00.0

DESIGN		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	
DATE		TITLE	
03.06.25		BAR	REV. A SHEET 1 OF 3
A	03.06.25	NEW ISSUE	SCALE 1:4

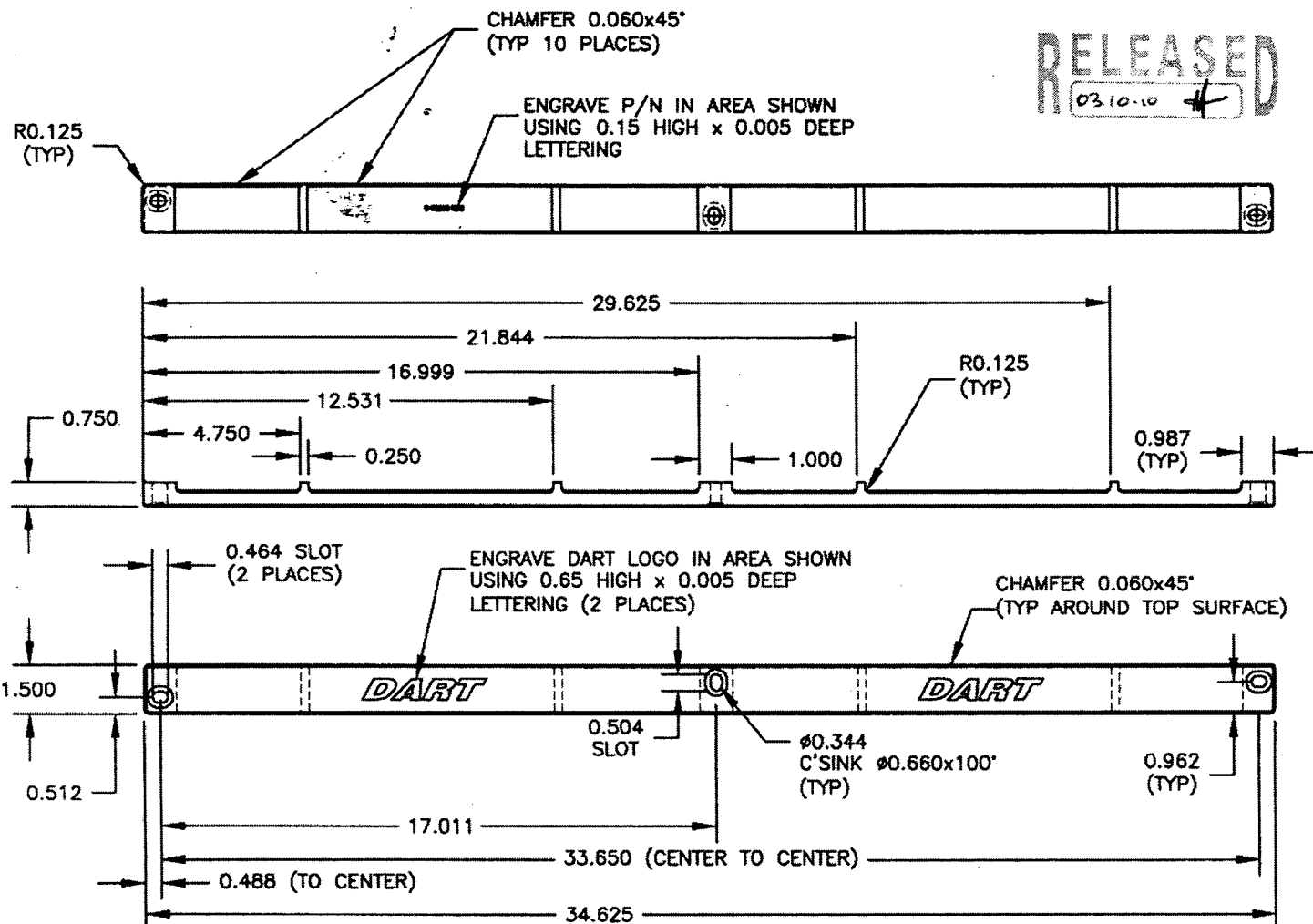


D3196-1 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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RELEASED
0310-10

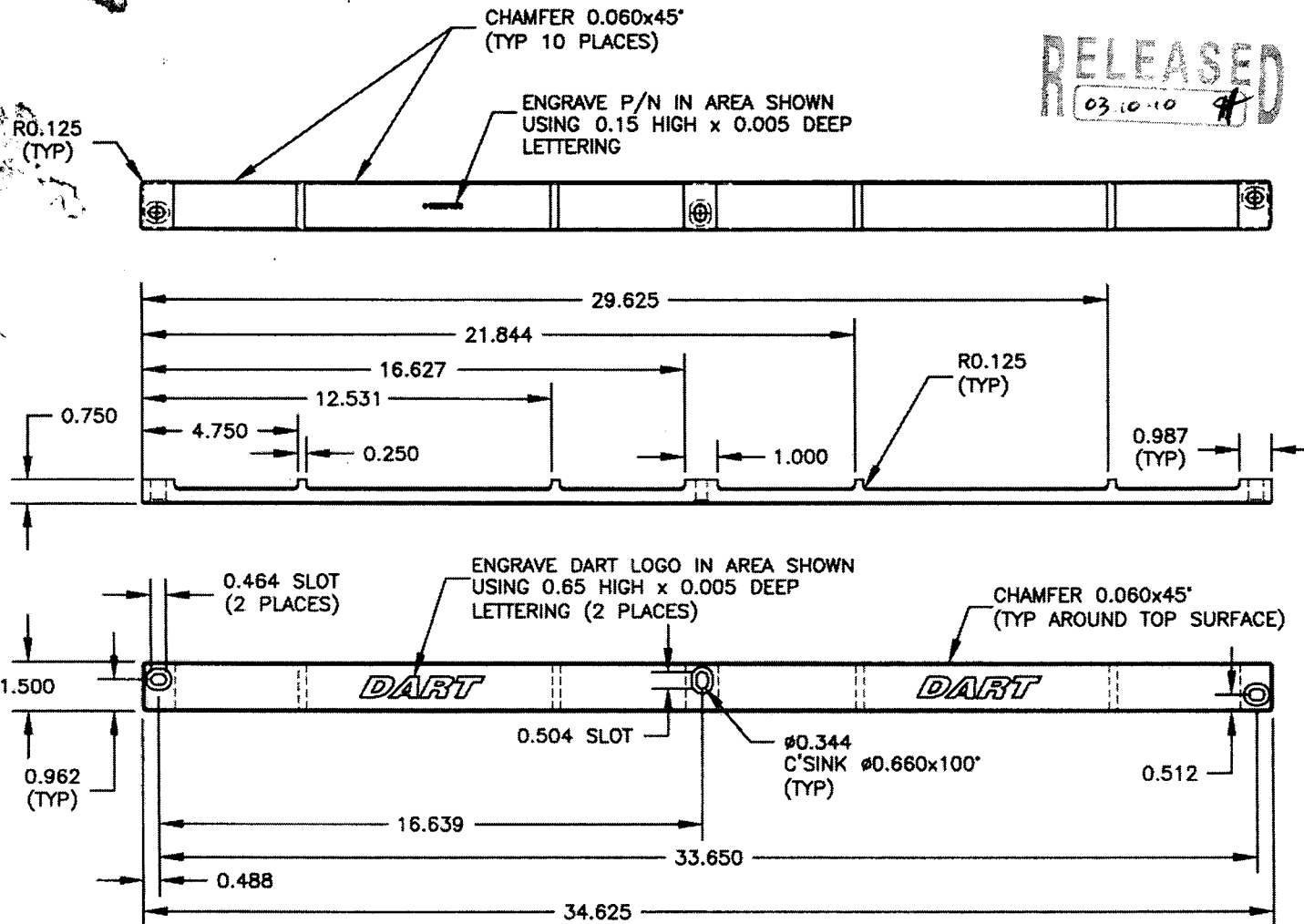
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
03.06.25	D3196	SHEET 2 OF 3
BAR	SCALE	1:5

D3196-3 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



D3196-4 BAR

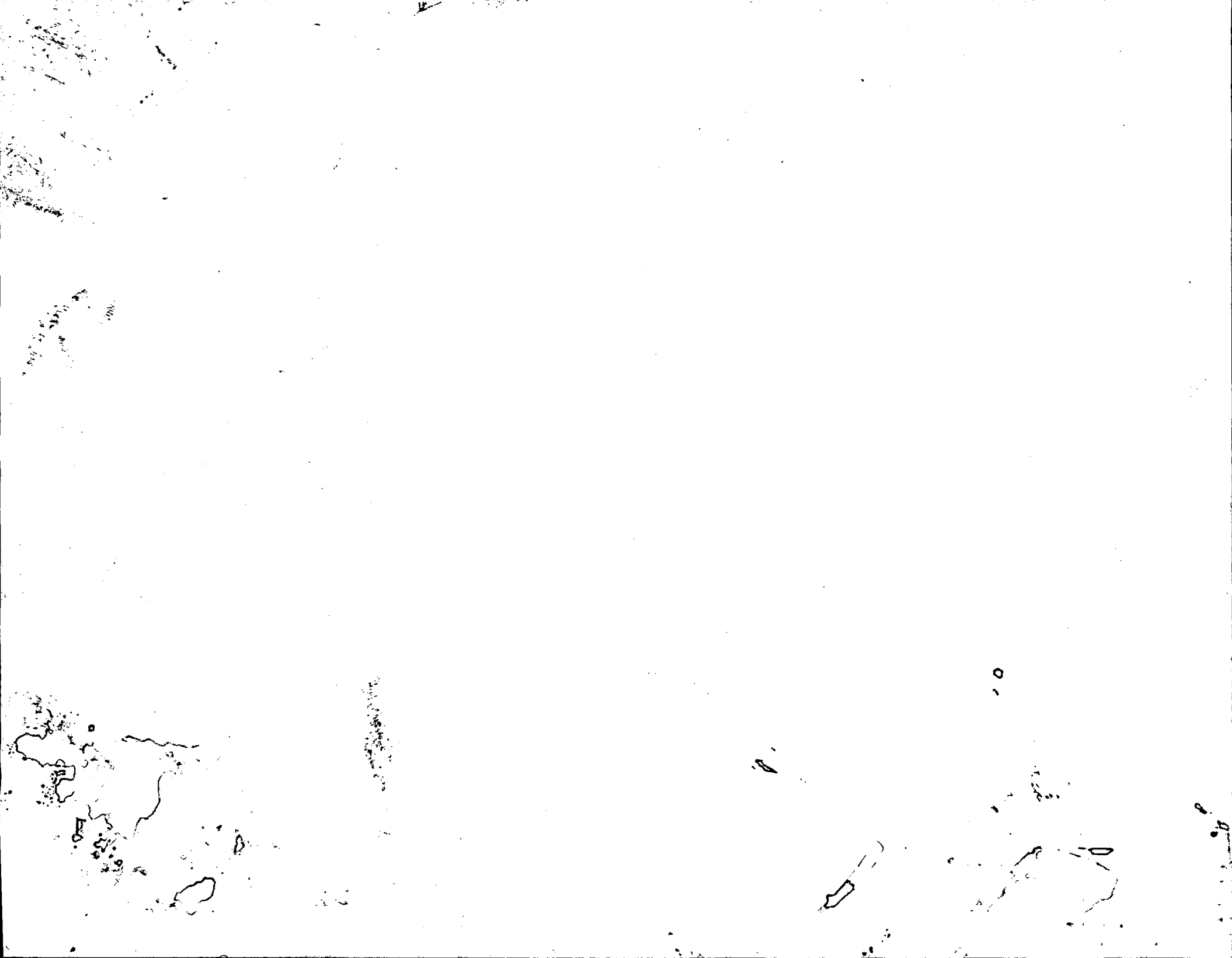
- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DART



DESIGN	APPROVED	DRAWING NO.	REV. A
CHECKED	APPROVED	D3196	SHEET 3 OF 3
DATE	03.06.25	TITLE	SCALE
		BAR	1:5

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA



Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
Job Number : 29986
Estimate Number : 10804
P.O. Number : N/A
This Issue : 15/12/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 00015
Written By :
Checked & Approved By :
Comment :

Drawing Name : D3196-1
Part Number : D31961
Drawing Number : REWORK-ECN871
Project Number : N/A
Drawing Revision : N/A
Material : N/A
Due Date : 22/12/2006 Qty: 16 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

-REMOVE FROM STOCK:

D3196-1 325849 8X

325108 1X

325100 1X

frank 10X

D412-702-021 326883 3X

325853 1X

D412-702-023 326074 3X

327722 1X

325705 2X

D412-702-033 327935 1X

(AND FROM WIP)

D412-702-011

2.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE ALL D3196-1'S FROM KITS

3.0 D31961

Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)
Bar

4.0 MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

REWORK D3196-1

PER ECN 871

06/12/18

16

Date: Friday, 15/12/2006 9:48:32 AM
 User: Linda Lacelle

Process Sheet

B25100

Customer : CC-DAR01 Dart Aerospace Ltd.
 Job Number : 29986
 Estimate Number : 10804
 P.O. Number : N/A
 This Issue : 15/12/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 00015
 Written By :
 Checked & Approved By :
 Comment :

Drawing Name : D3196-1
 Part Number : D31961
 Drawing Number : REWORK-ECN871
 Project Number : N/A
 Drawing Revision : N/A
 Material : N/A
 Due Date : 22/12/2006

Qty: 16 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

-REMOVE FROM STOCK:

D3196-1 B25849 8X B25108 1X B25100 1X ¹⁶ ^{10X}

D412-702-021 B26883 3X B25853 1X (4)

D412-702-023 B26074 3X ~~B27235~~ 1X B25765 2X (5)

D412-702-033 327 935 1X (1)

(AND FROM WIP)

D412-702-011

06/12/18

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE ALL D3196-1'S FROM KITS

3.0 D31961 Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)

Bar

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

REWORK D3196-1
 PER ECN 871

06/12/18

16